

Work Order ID 77469

77469

Page 1

December-08-11 8:00:48 AM

Item ID: D2989-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket Lid Assembly
 Start Date: 08/12/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 20/12/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/08 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100 0.00
 100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989
 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
 ****cut cutouts with zip cut as per dwg D3832****
 3- remove from jig and weld lable plate as per dwg D2989
 A/R ER316 S.S. Rod Batch: 114649
 *** PLEASE NOTE****
 IF MAKING -043A :
 ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
 DSI9473

11.12.14 1x Ø

110 0.00
 110 QC9- Inspect visual per QS1004- Fusion Welds
 QC Memo 0.00
 Quality Control

BE
11.12.14

1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D2989-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid Assembly

Start Date: 08/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

Xφ m-11/12/16

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

131

Wing Walk as per dwg QSI005 4.4 Batch 119024 0.00***131***

HandFinish

Memo

0.00

Hand Finishing

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: 118119*Handwritten signature and date: 11/12/16**Handwritten signature and date: 11-12-19**Handwritten note: W11A480**Handwritten note: 10:30 400 OF 11:00*

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140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
141	Identify as per dwg & Stock Location: 6-A	0.00							
141									
Packaging	Memo w/o	0.00							
Packaging	77465								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

11-12-20
(1)

W/O:		WORK ORDER CHANGES					
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Picklist Print

December-08-11 8:00:57 AM

Page 1

Work Order ID: 77469

77469

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	16.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				16					
				71372				4					
				72297				12					
D2506 *D2506* Label Plate		Manufactured	No			100	Each	9.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				9					
				74142				9					
D2512-7 *D2512-7* Rib		Manufactured	No			100	Each	5.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				5					
				67445				1					
				71220				4					

W/O:		WORK ORDER CHANGES					
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December-08-11 8:00:57 AM

Page 2

Work Order ID: 77469

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

32.0000

2

2

D2581

Mounting Bracket

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA005

32

69739

2

70766

2

73762

3

75280

25

2

D2989-13

Manufactured No

100

Each

8.0000

2

2

D2989-13

Rib

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA005

8

~~71556~~

2

~~71556~~

6

B72410 → ①
B71556 → ①

~~②~~ ~~②~~

D2989-19

Manufactured No

100

Each

8.0000

2

2

D2989-19

Rib

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA006

8

71477

2

72411

6

2

D3832-3

Manufactured No

100

Each

3.0000

1

1

D3832-3

Mesh (Lid)

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA

3

71301

3

1

December-08-11 8:00:57 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

December-08-11 8:00:57 AM

Page 3

Work Order ID: 77469

77469

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No

100 Each

17.0000

2

2

D3833-3

Mesh (Lid End)

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA

17

67460

17

D3836-041

Manufactured No

100 Each

3.0000

1

1

D3836-041

Rib Assembly (Basket Lid, LH)

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA

2

72412

2

WA005

1

71746

1

D3836-042

Manufactured No

100 Each

3.0000

1

1

D3836-042

Rib Assembly (Basket Lid, RH)

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA

2

72413

2

WA005

1

71745

1

D3852-041

Manufactured No

100 Each

3.0000

1

1

D3852-041

Rib Assembly

**

Pl 11.12.12

Location

Loc Qty

Loc Code

WA

3

70722

3

December-08-11 8:00:57 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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December-08-11 8:00:57 AM

Work Order ID: 77469

77469

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

4.0000

1

1

D3852-042

Rib Assembly

**

Planta 12

Location

Loc Qty

Loc Code

WA

4

66089

1

70723

3

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOWN COPY
REFURSED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73469 M.L.J
11/12/08

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3838-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS		
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	DS	D2989	SHEET 1 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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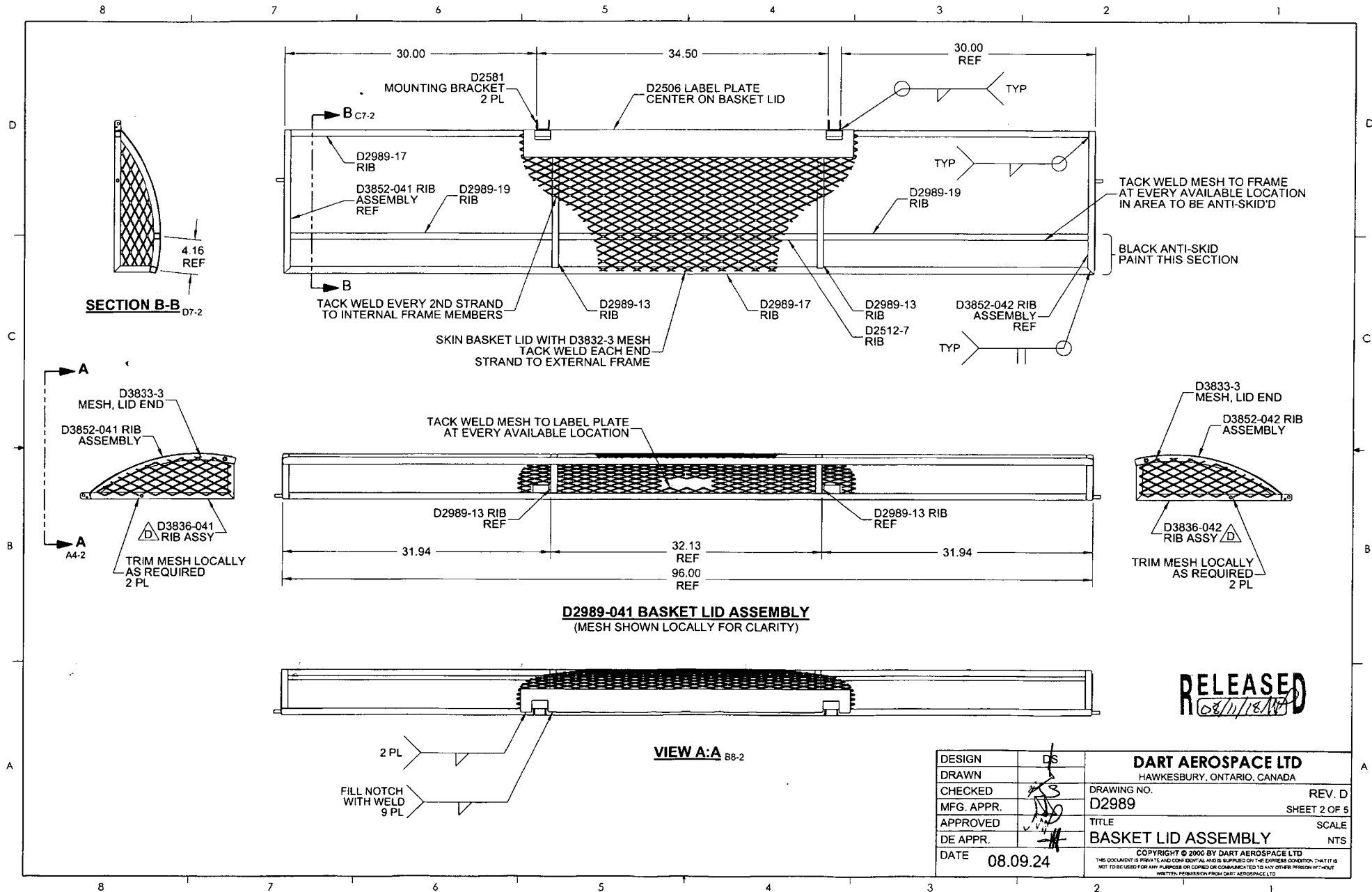
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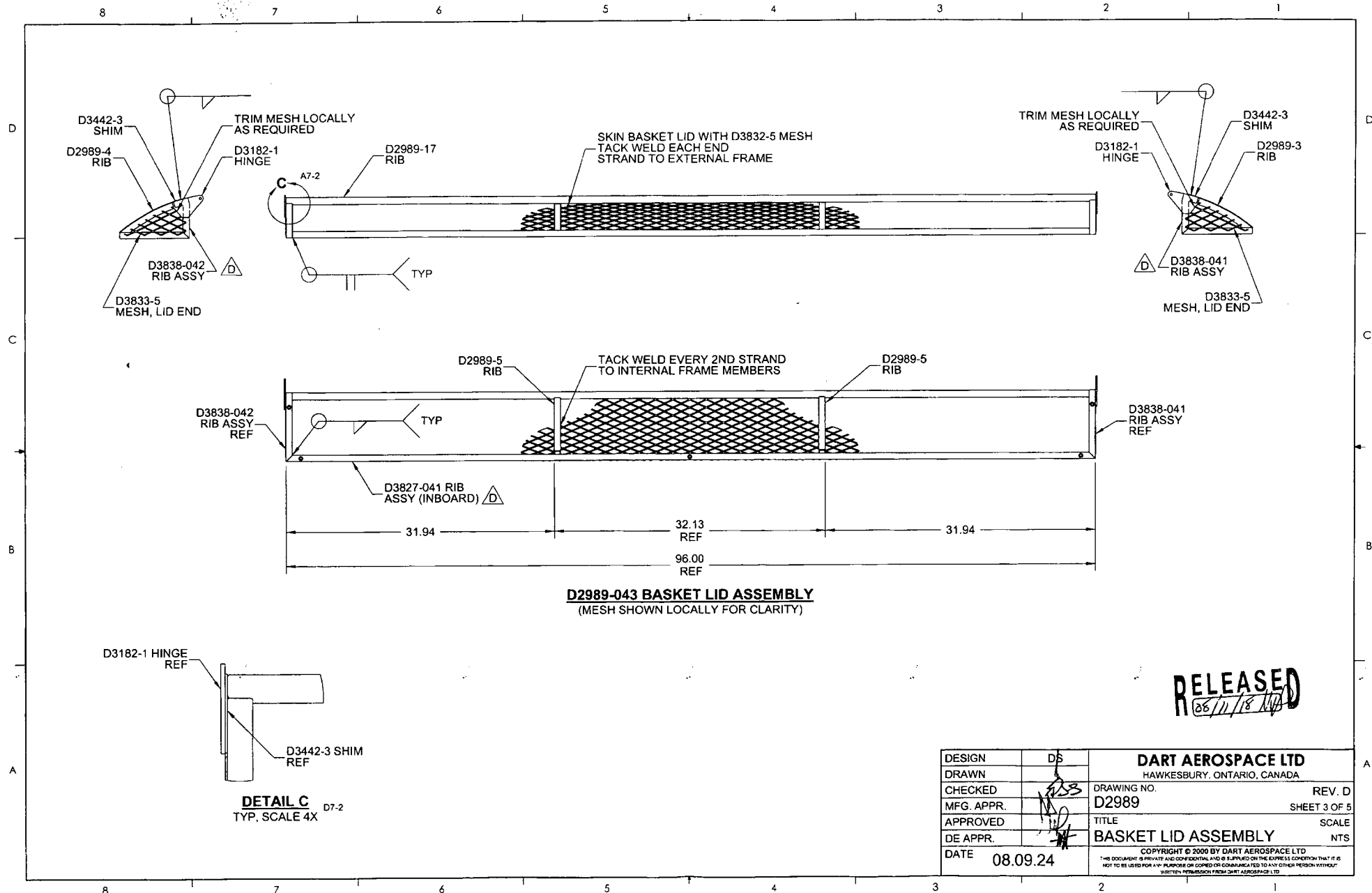
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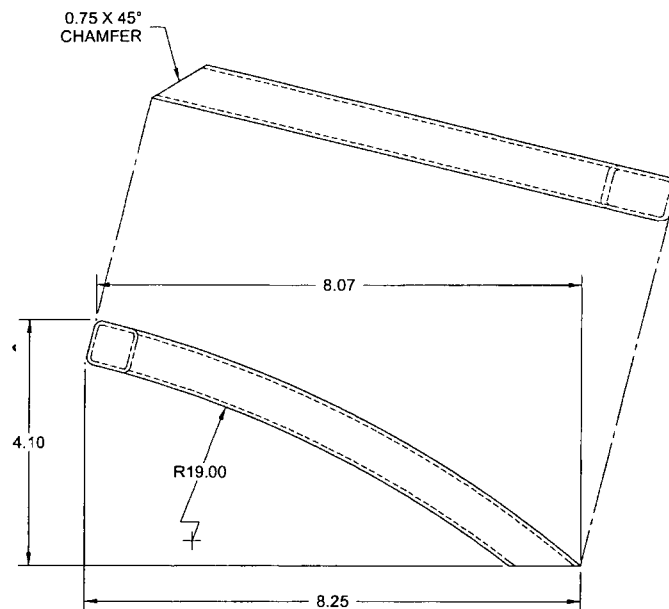
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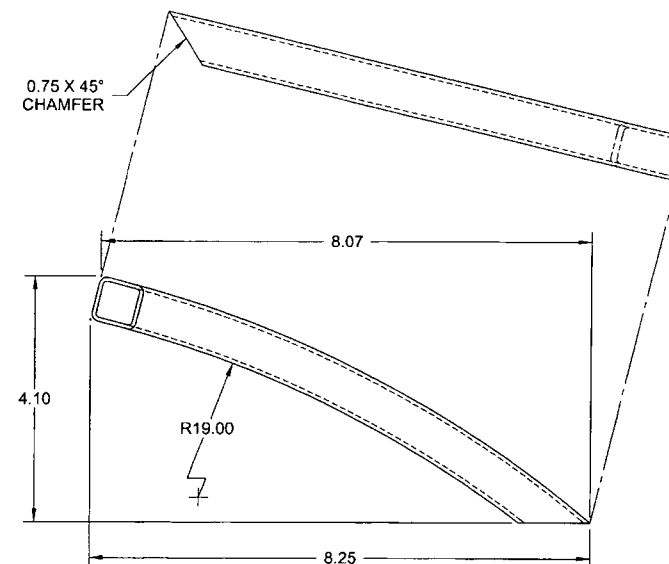
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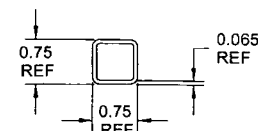


D2989-3 RIB



D2989-4 RIB

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



TYPICAL SECTION VIEW

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 4 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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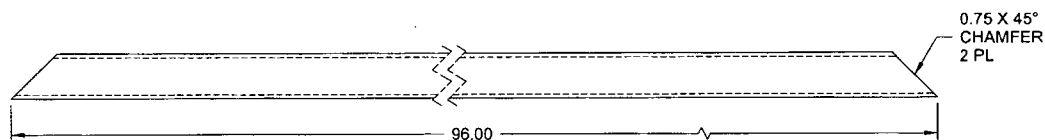
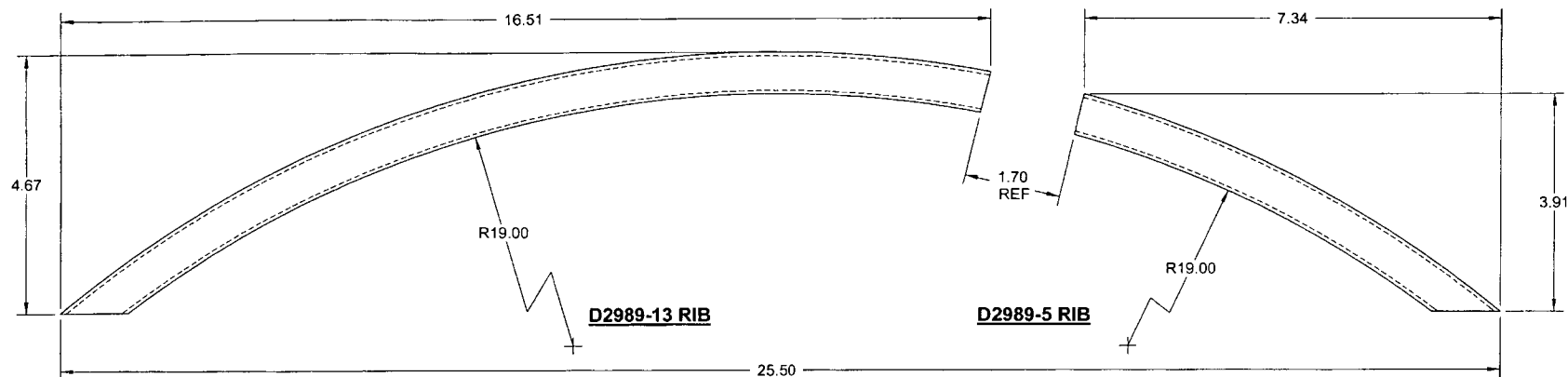
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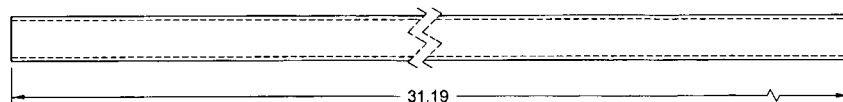
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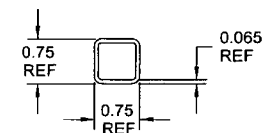
77469



D2989-17 RIB



D2989-19 RIB



TYPICAL SECTION VIEW

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.



FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET*)
2		X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	1	1	D3953-5	GAS SPRING STUD (BASE)
7	2	1	1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE LID OPENER PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-041A
D350-607-043 BASKET WITH AUTOMATIC LID OPENER INSTALLED= D350-607-043A
D350-607-045 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-045A
D350-607-047 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-047A

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	09.11.11
CERT. NO.:	SH94-14
ISSUE NO.:	4

C	SHEET 1 PL, -143 INSTL, ITEM 6 QTY WAS 2, ITEM 7 WAS 0.	AJS	09.11.11
B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR) INSTALLATIONS RENAMED.	AJS	09.11.06
A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM AS FOLLOWS:

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

NOTE: ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.



- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
- 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-143 AUTOMATIC LID OPENER INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.




- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPPERD (DE # 02)	
DATE:	09.11.11
CERT. NO.:	SH94-14
ISSUE NO.:	4

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
 - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
 - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
 - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
 - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
 - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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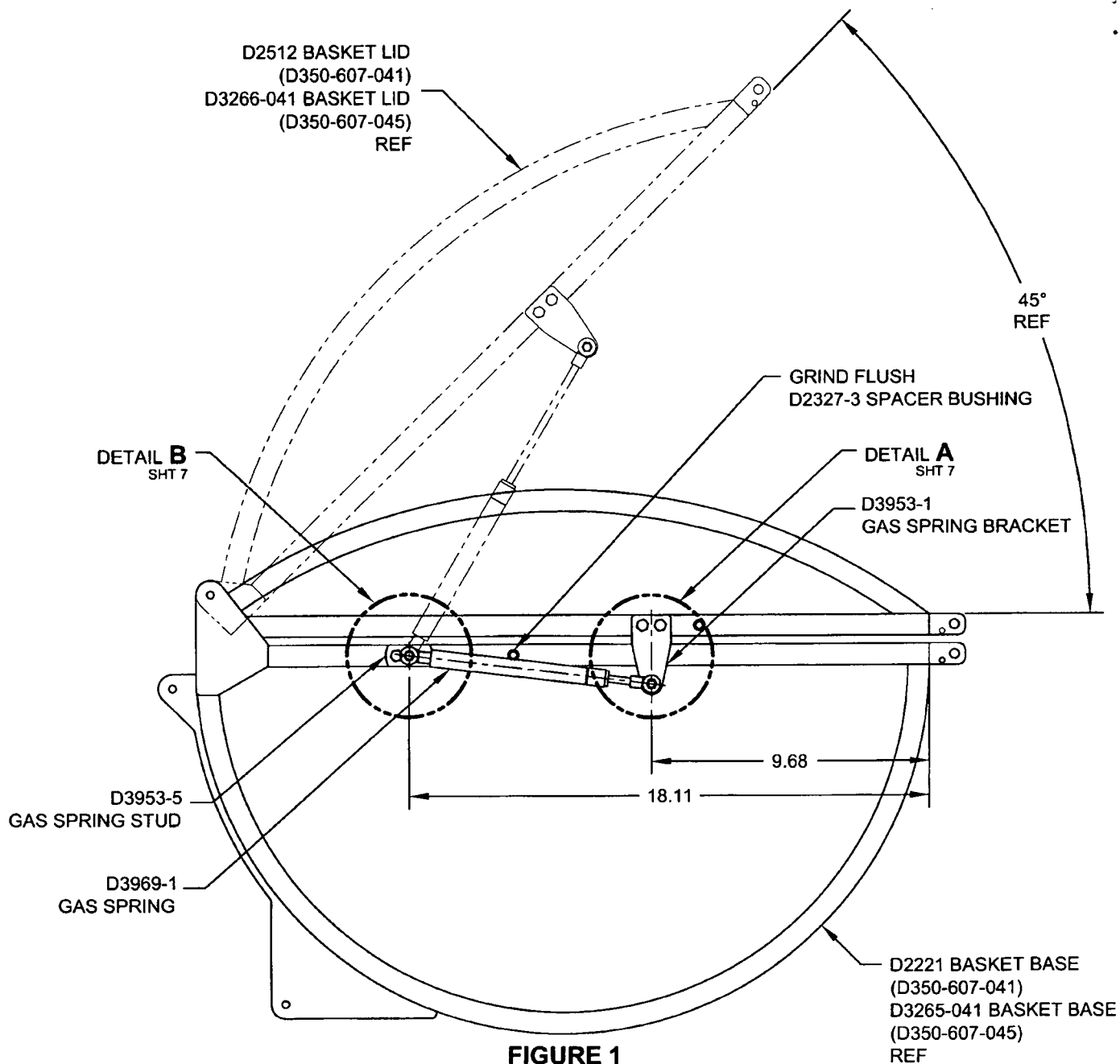


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 5 OF 8
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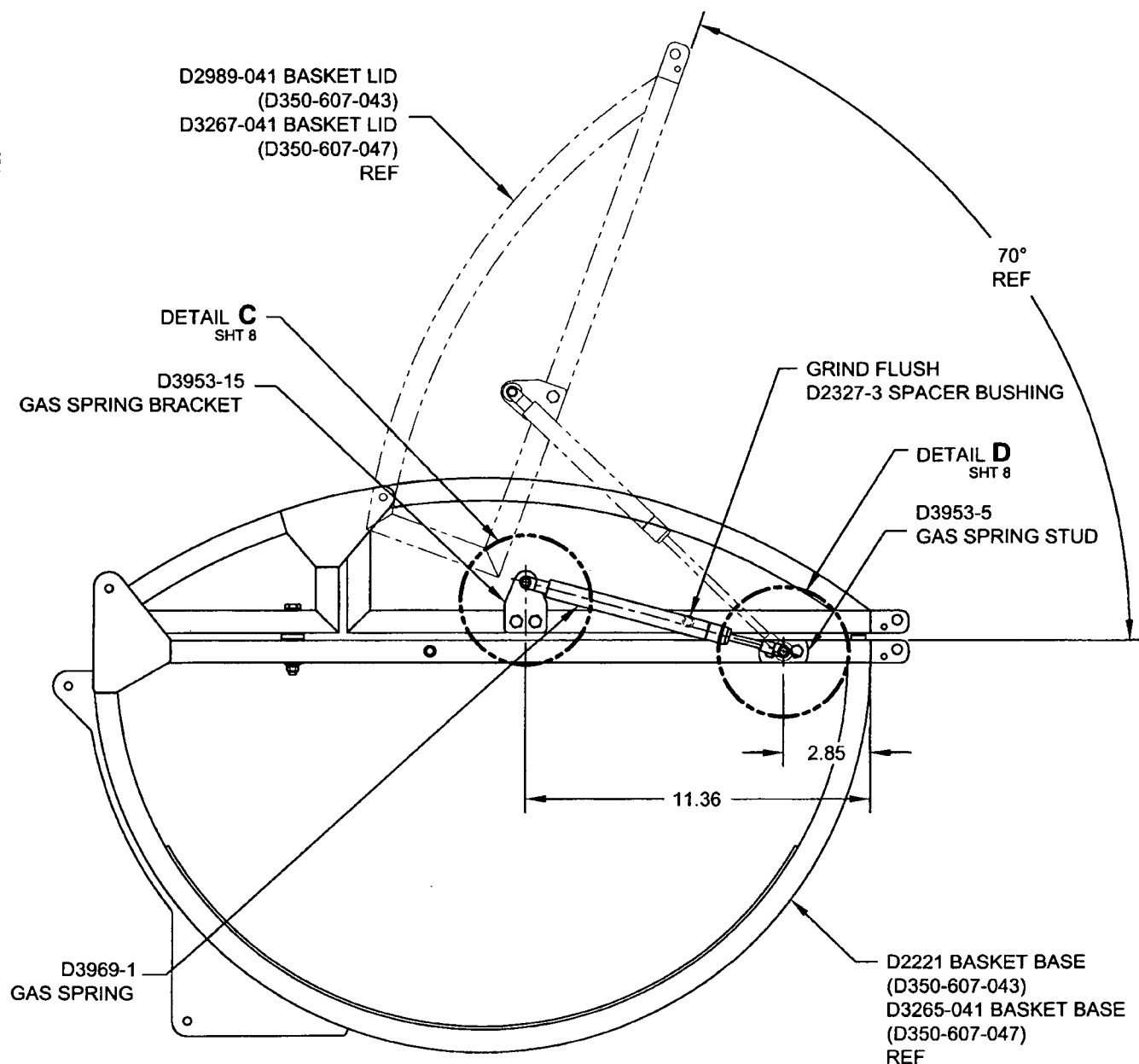


FIGURE 2
D350-607-143 AUTOMATIC LID OPENER INSTALLATION
 (1 END ONLY)

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 DAO # 01-O-01

APPROVED

BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 09.11.11
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 6 OF 8
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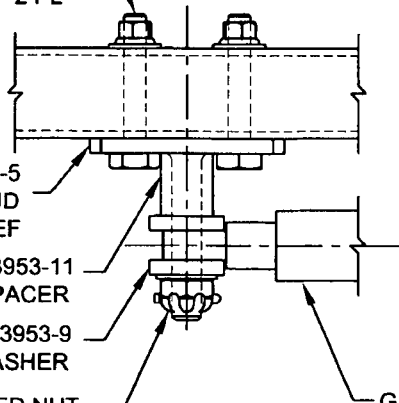
AN3C11A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF

D3953-11
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER



VIEW F-F

AN3C16A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

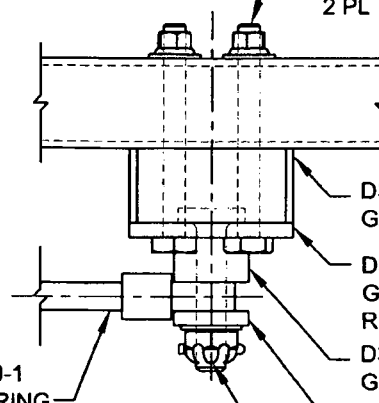
D3953-13
GAS SPRING SPACER

D3953-1
GAS SPRING BRACKET
REF

D3953-7
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

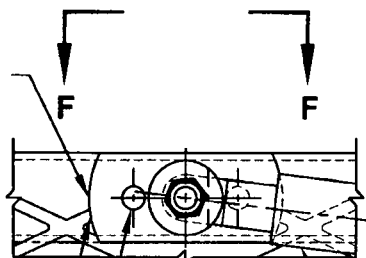


VIEW E-E

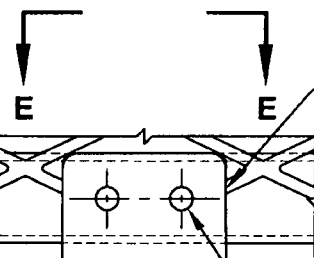
D3953-5
GAS SPRING STUD
REF

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU
2 PL



DETAIL B



TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

D3953-1
GAS SPRING BRACKET
REF

DETAIL A

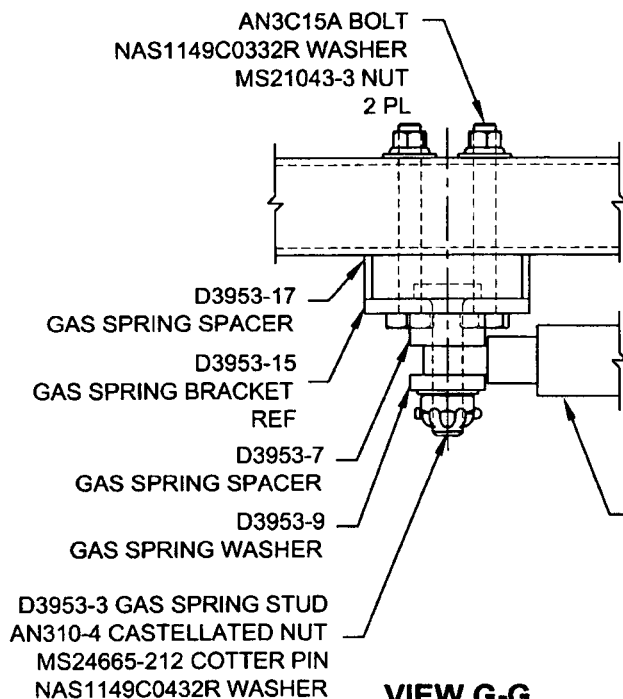
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

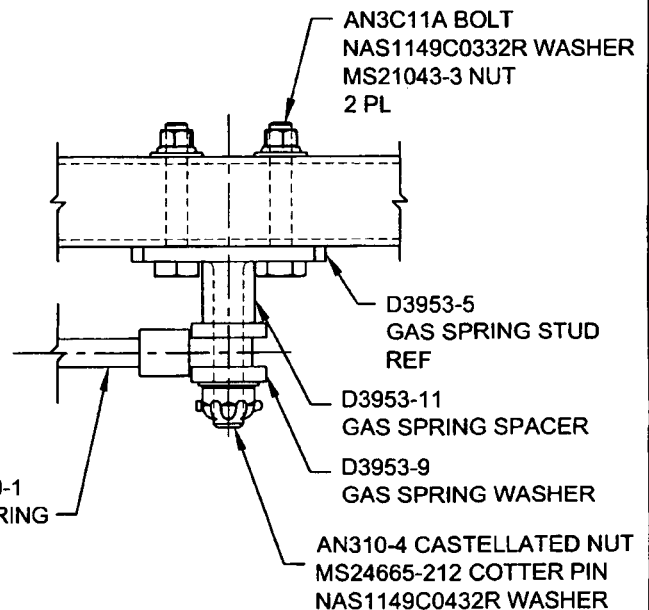
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

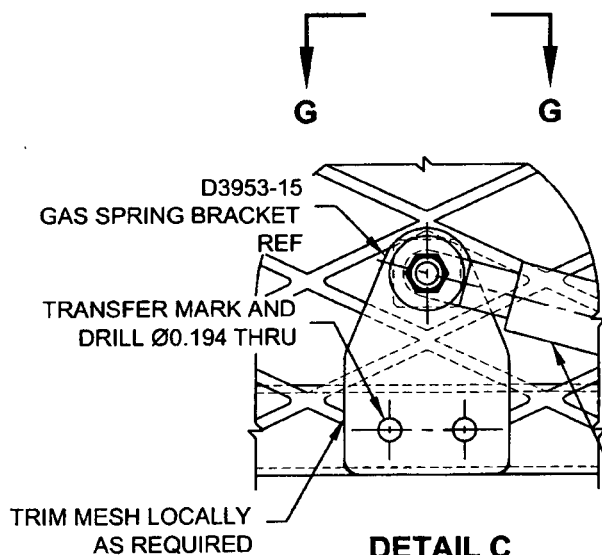
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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 7 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
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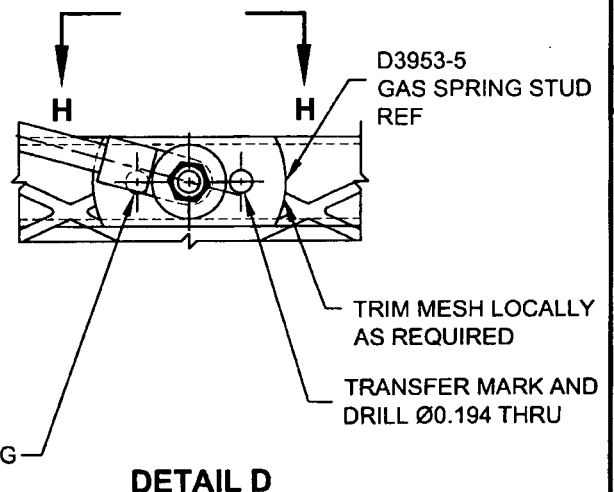
VIEW G-G



VIEW H-H



DETAIL C






DETAIL D

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
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APPROVED		TITLE	SCALE
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